

Work Order ID 78580

78580

Page 1

Wednesday, January 11, 2012 1:10:58 PM

Item ID: D2965

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap, 105 Skidtube

Start Date: 1/11/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 1/11/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference: REPAINT

Approvals: Process Plan: *MF*

Date: 12-01-11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2965

Rev B

210

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

210

Powdercoat

Powder Coating

Memo

SCUFF LIGHTLY AND REPOWDER COAT GREY SANDTEX

*Start Time: 3:30
Temp: 320°F
Finish Time: 4:00*

2X Ø M-L 12/01/11

220

QC3- Inspect Part Finish

0.00

220

QC

Quality Control

Memo

0.00

2 BR 12-1-12

230

Identify as per dwg & Stock Location:

0.00

230

Packaging

Packaging

Memo

ID AND STOCK UNDER NEW BATCH NUMBER

FR2

2 BR 12-1-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78580***78580***

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cap, 105 Skidtube

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Cust Item ID:

Required Date: 1/11/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference: REPAINT

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

12/1/12

MF
12-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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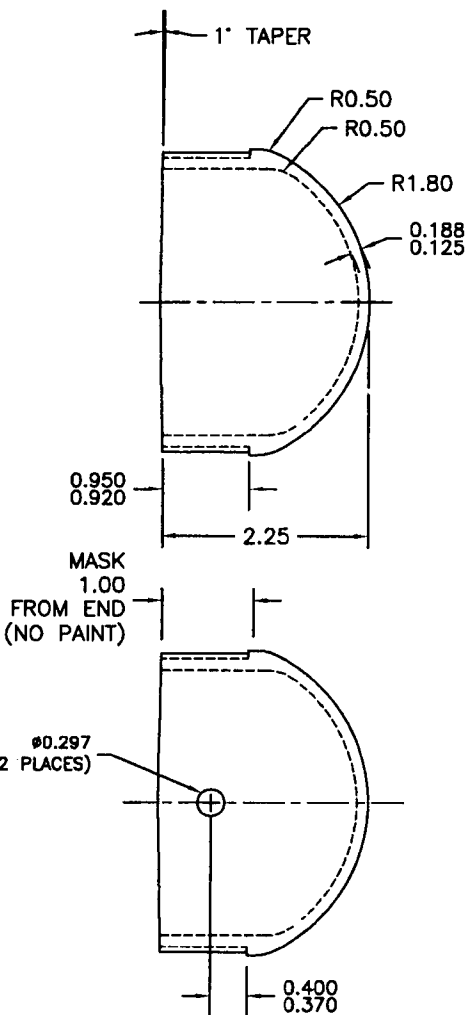
NOTE: Date & initial all entries

DART

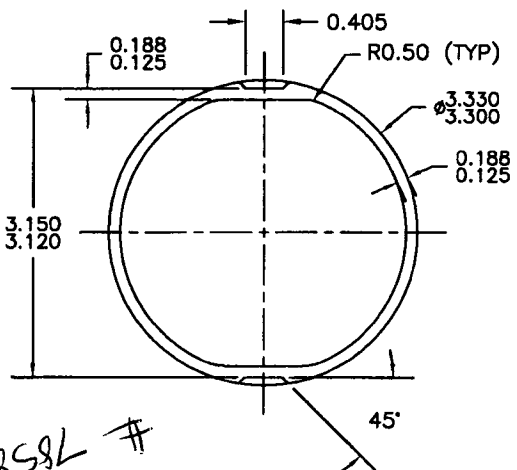
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06.12.12

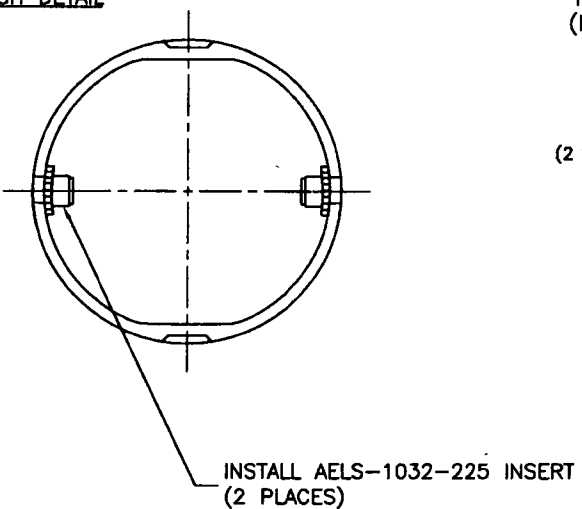
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	06.11.01	DRAWING NO.	D2965	REV. B
		TITLE	CAP	SHEET 1 OF 2
		SCALE	1:2	
A	00.02.24	NEW ISSUE		
B	06.11.01	ADD -3 CAP		



D2965 CASTING DETAIL



D2965 FINISH DETAIL



D2965 CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	REV. B
DATE	06.11.01	TITLE	D2965	SHEET 2 OF 2	SCALE
			CAP		1:2

RELEASED

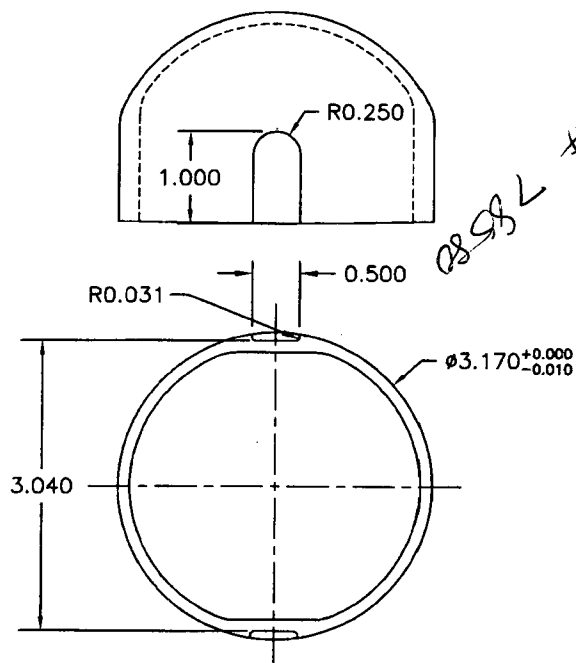
06.12.02

MASK
1.00
FROM END
(NO PAINT)

Ø0.297
INSTALL AELS-1032-130
AFTER FINISH
(2 PLACES)

0.400
0.370

D2965-3 FINISH DETAIL



D2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP

- 1) MATERIAL: MAKE FROM D2965 CAP
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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